

# Work Order ID 62026

September 15, 2010 8:03:47 AM

Page 1

Item ID: D3531-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket Assembly

Start Date: 9/15/10 Start Qty: 3.00

Cust Item ID:

Required Date: 9/16/10 Req'd Qty: 3.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3531

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D3531

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

120

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

1:50pm

OVEN TEMPERATURE:

2:20pm FINISH TIME:

320 F

x2

x1

RTO

Signature: [Handwritten Signature] 10/09/15 (2)

Signature: [Handwritten Signature] 10/09/15

(x2) (x1)

=) x2 Hl 10/09/15

x2 d

## Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3531-041 PAR #: \_\_\_\_\_ Fault Category: Small Eng NCR: Yes No DQA: 7 Date: 6-05-23  
Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>62026</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>26/09/15</u>	<u>100</u>	<u>1 part Scrap rivet was <del>over</del> checked when removed Note came bigger</u> <u>2.c. process = Thin material</u>	<u>[Signature]</u>	<u>Scrap + Destroy</u>	<u>[Signature]</u> <u>10/09/15</u>	<u>S</u> <u>10/09/15</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>10/09/15</u>

NOTE: Date & initial all entries

# Work Order ID 62026

September 15, 2010 8:03:48 AM

Page 2

Item ID: D3531-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket Assembly

Start Date: 9/15/10 Start Qty: 3.00

Cust Item ID:

Required Date: 9/16/10 Req'd Qty: 3.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MA 10 01 15 (2)

140

Identify as per dwg & Stock Location: 233

0.00



Packaging

Memo

0.00

Packaging

10/16 01 (20)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/16 01

pl 10-2-16 (2)

# Picklist Print

September 15, 2010 8:03:45 AM

Page 1

Work Order ID: 62026

Parent Item: D3531-041

Parent Item Name: Bracket Assembly

Start Date: 9/15/10

Required Date: 9/16/10

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3531-1		Manufactured	No			100	Each	8.0000	1	3			
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Bracket

Location

Loc Qty

Loc Code

st238

8

53912

8

D3531-3		Manufactured	No			100	Each	3.0000	1	3			
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Bracket Front Plate

Location

Loc Qty

Loc Code

ST068

3

50214

3

MS20470AD4-4		Purchased	No			100	Each	3,758.000	12	36			
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Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

3758

112314

30

113368

92

115470

3636

\* 1114761

3 8/10/09/15

3 8/10/09/15

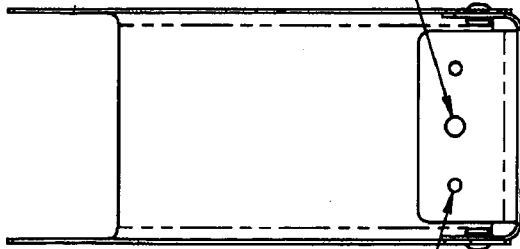
36 8/10/09/15

36

**DART**

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED HA	DRAWING NO. D3531	REV. A SHEET 1 OF 3
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	

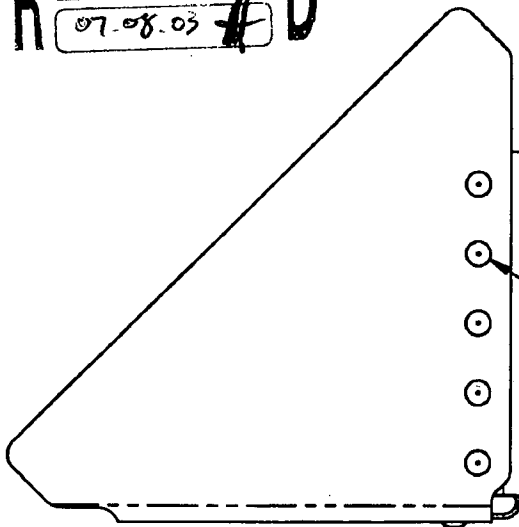
4  
TRANSFER DRILL #9 ( $\phi 0.196$ )



TRANSFER DRILL #30 ( $\phi 0.129$ )  
INSTALL MS20470AD4-4 RIVET  
(2 PLACES)

4

RELEASED  
07.08.03



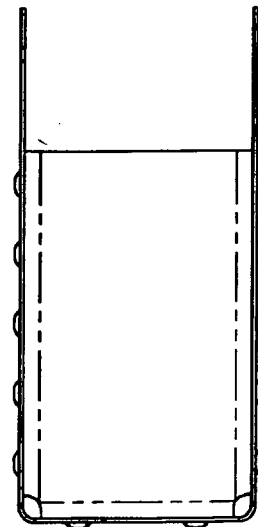
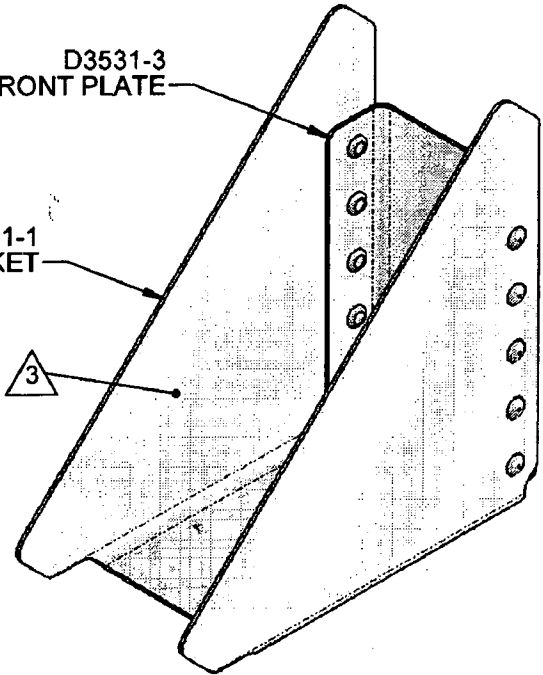
MS20470AD4-4  
(10 PLACES)

41062026

D3531-3  
BRACKET FRONT PLATE

D3531-1  
BRACKET

3



### D3531-041 BRACKET ASSEMBLY

#### NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK  
SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING  
WHITE MARKER ON INSIDE OF BRACKET  
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET  
THROUGH D3531-3 BRACKET FRONT PLATE  
BEFORE FINISHING

#### PARTS LIST

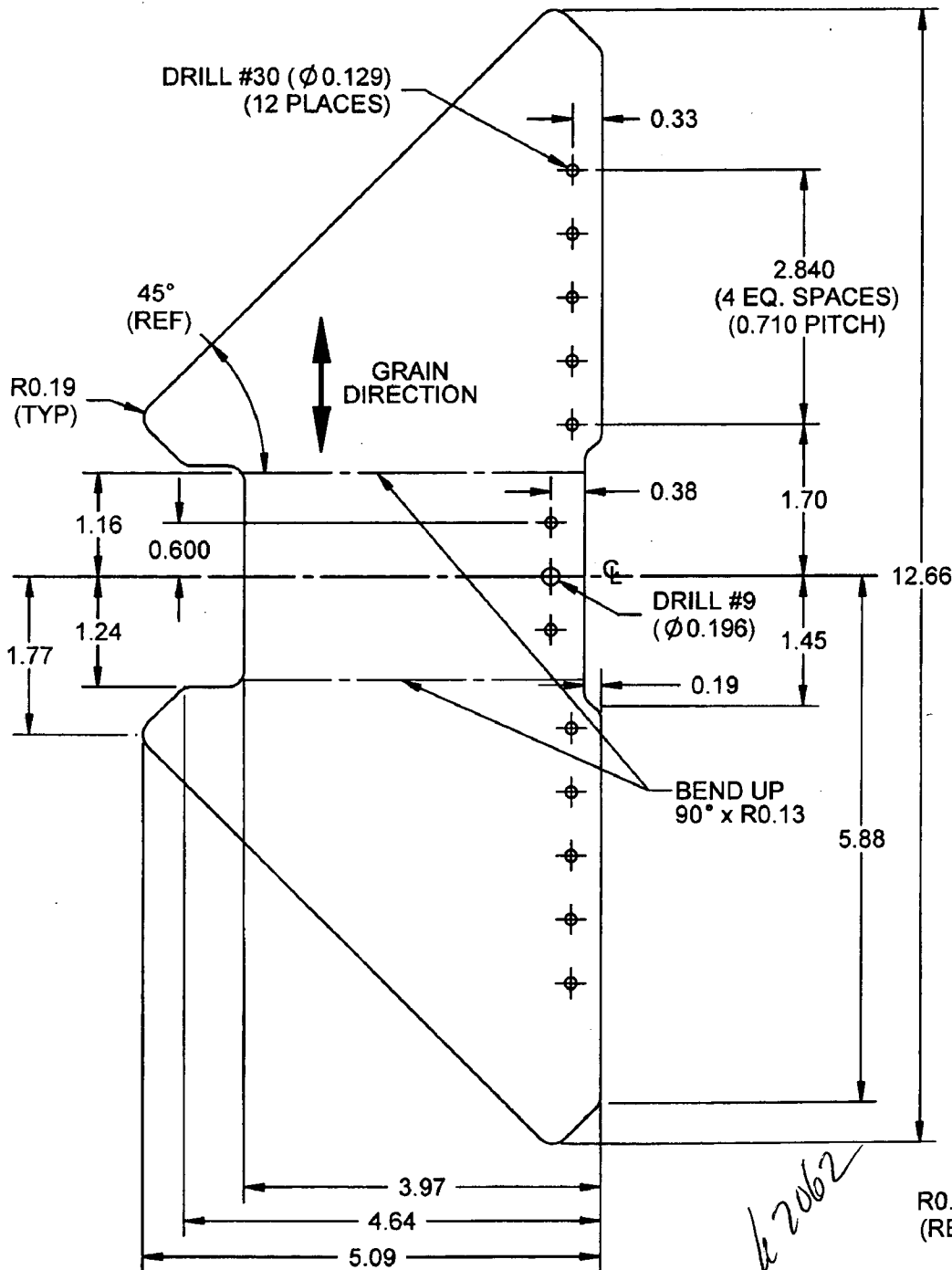
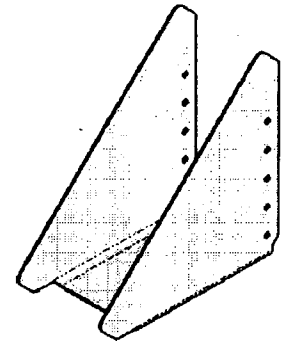
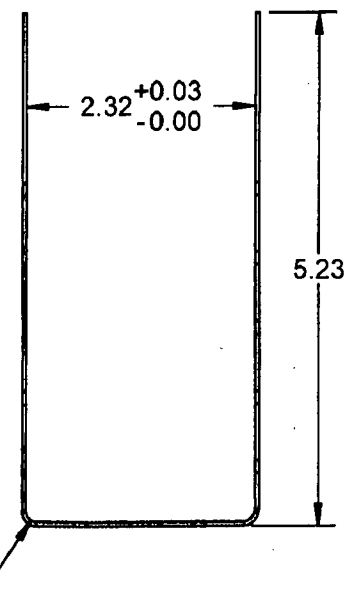
QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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**DART**

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>HA</b>	DRAWING NO. <b>D3531</b>	REV. <b>A</b>
DATE <b>07.06.19</b>		TITLE <b>BRACKET ASSEMBLY</b>	SHEET 2 OF 3 SCALE 1:2

**D3531-1F FLAT PATTERN****RELEASED**  
07.08.03**D3531-1 BRACKET****NOTES:**

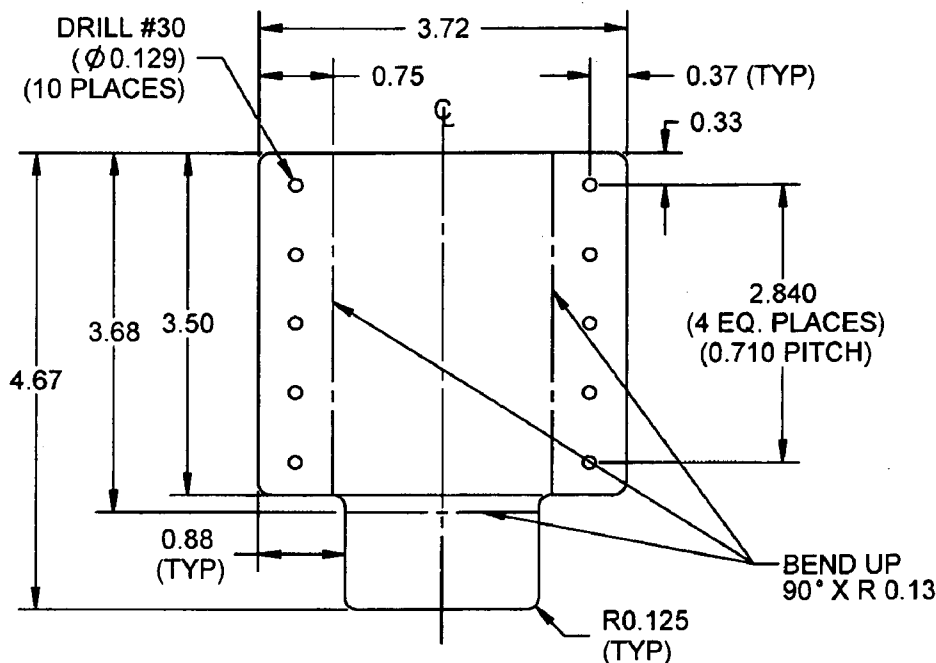
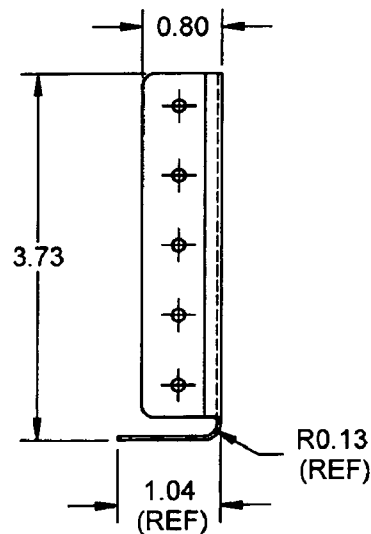
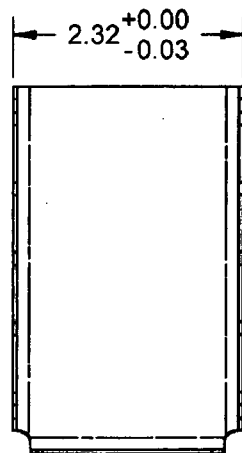
- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

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**DART**

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>#</b>	DRAWING NO. <b>D3531</b>	REV. <b>A</b> SHEET 3 OF 3
DATE <b>07.06.19</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:2

**D3531-3F FLAT PATTERN****D3531-3 BRACKET FRONT PLATE****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$

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